

Work Order ID 71347

Tuesday, June 28, 2011 1:30:22 PM



Page 1

Item ID: D350-636-101

Accept



Setup Start



Revision ID:

Item Name: Toe Step, LH/RH

Stop



Start Date: 6/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3487

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

6061.100

5/28/12

Handwritten: CL 11-7-12 (WHITE LABEL) 8

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg *** D3487-1***

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

Handwritten: B11-6-29

Handwritten: 8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-29 (8)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 11/06/29

(18)

150

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3487

Sb 11/07/06

(8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D350-636-101

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Setup Start



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Stop



Item Name: Toe Step, LH/RH

Start Date: 6/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



0.00 8/11/07/07

QC

Memo

Quality Control



170

Chemical Conversion Coat per QSI005 4.1

0.00



0.00

HandFinish

Memo

Hand Finishing

8 0 BL 11-7-7

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



0.00

Powdercoat

Memo

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117745

32005

8-45

9-15

8X 0 M 11/07/08

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Tuesday, June 28, 2011 1:30:22 PM

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Item Name: Toe Step, LH/RH

Start Date: 6/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|---------------------------|----------------|
| 190 HandFinish Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch <i>M117863</i> Memo | 0.00 | | | | <u>8</u> | | <u>BR 11-7-11</u> | |
| 200 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 | | | | <u>8</u> | <u>0</u> | <u>MR 11/7/11</u> | |
| 210 Packaging Packaging | Packaging Memo Identify and pack for shipping as per PPP D350-636-101 Location: _____ PPP Rev: <u><i>A</i></u> | 0.00 | | | | | | <u><i>Per 11/2/11</i></u> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71347

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Revision ID:

Stop



Item Name: Toe Step, LH/RH

Start Date: 6/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/12 [Signature]

CMF 11-07-12

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 28, 2011 1:30:28 PM

Page 1

Work Order ID: 71347



Parent Item: D350-636-101



Parent Item Name: Toe Step, LH/RH

Start Date: 6/28/2011



Required Date: 7/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
11.03.15 now made in house DD verf:JLM

IPP Rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M6061T6S.100  | | Purchased | No | | | 110 | sf | 34.5000 | 0.7942 | 5.016 | 6.6 | | |
| 6061-T6 .100 Sheet | | | | | | | | |  | | 11-6-29 | | |

Location

Loc Qty

Loc Code

MAT021

34.5

102201

2.5

118072

32

118072

8

| W/O: | | WORK ORDER CHANGES | | | | | |
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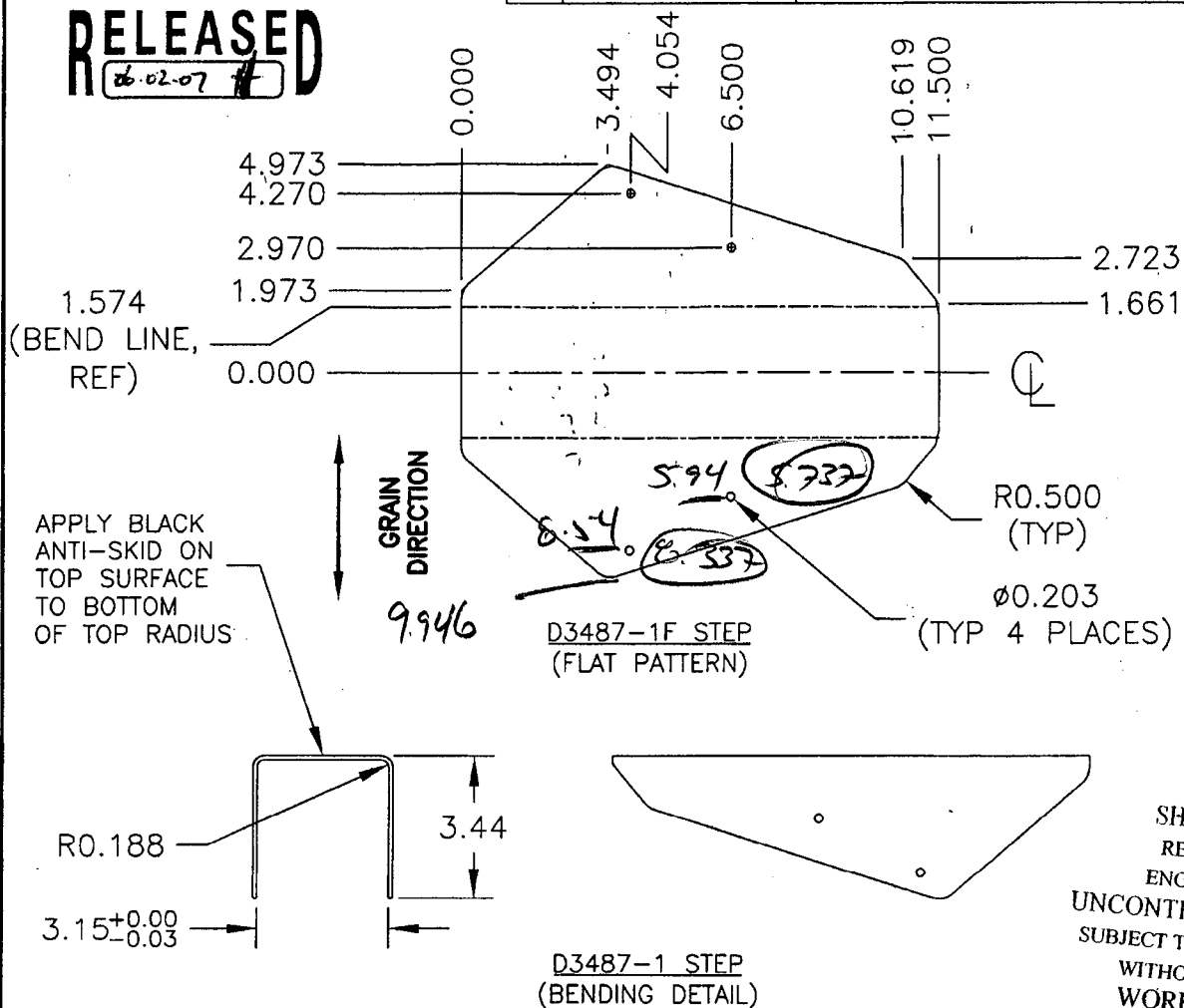
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED # | APPROVED # | DRAWING NO. D3487 | REV. A SHEET 1 OF 1 |
| DATE 06.01.16 | | TITLE STEP | SCALE 1:4 |
| A | 06.01.16 | NEW ISSUE | |

RELEASED
06-02-07 #**D3487-1 STEP**

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71347

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